

the bottom of the jig when the work was removed. At the same time this would prevent the straps from swiveling around the screws when not clamped.

In Fig. 15, the part *B* in Fig. 13 is shown clamped in position for drilling, the opposite side of the jig being used for this purpose. In jig design of this kind it is necessary to provide some means so that the parts *A* and *B* will be placed each on the correct side of the jig, or, as mentioned, the jig should be made "fool-proof." In the present case, the parts cannot be exchanged and placed on the wrong side, because the cover or guard *B* cannot be held by the three straps shown in Fig. 14, as the screws

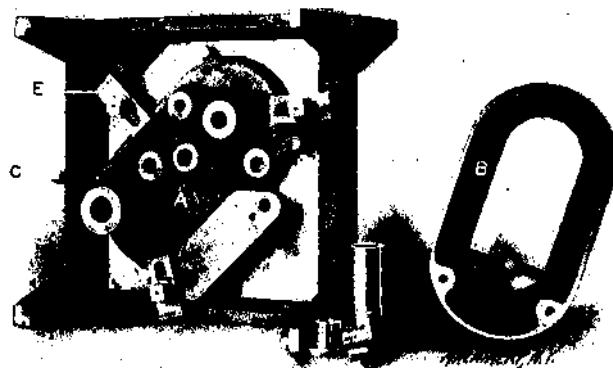


Fig. 14. Drill Jig shown in Fig. 13 with Work In Place

for the straps are not long enough. On the other hand, the piece *A* could not be placed on the side shown in Fig. 15, because the long bolt and strap used for clamping on this side would interfere with the work.

It may appear to be a fault in design that three straps are used to fasten the piece *A* in place, and only one is employed for holding piece *B*. This

difference in clamping arrangement, however, is due to the different number and the different sizes of holes to be drilled in the different pieces. The holes in the piece *A* are larger and the number of holes is greater, and a heavier clamping arrangement is, therefore, required, inasmuch as the thrust on